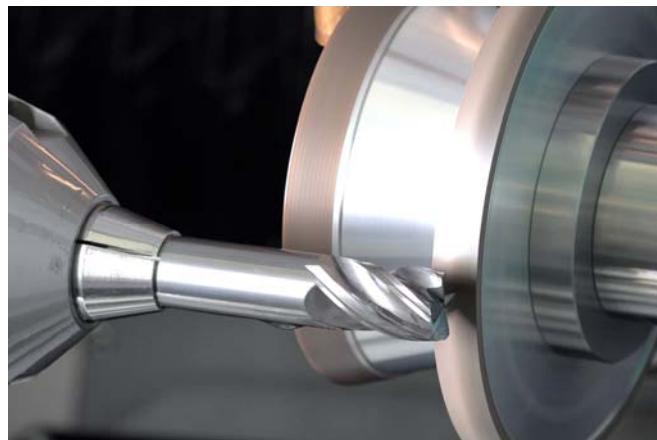


Chatter Free End Mill D16mm

A01-010

Chatter Free End Mill in carbide with diameter 16mm, cutting edge length 35mm, 4 flutes, 2 center cutting, helix angle 35 / 38° and individual division. Flut has been ground from solid in one pass. First clearance with CAM and second with recess.



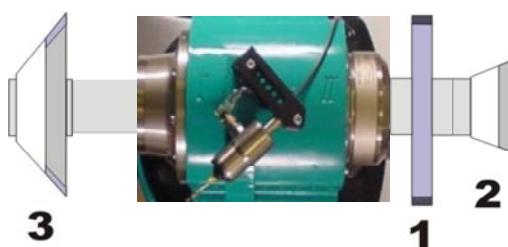
1. Cycletime for Production

Workpiece: Ø16 L25, Z4 / Z2 Material CARBIDE								
Operations	prob	flute	OD 2	gash	end 2	end 1	chamfer	OD 1
Feed [mm/Min]	2000	50	150	20	100	100	500	100
Power [kW]	0	2	1	1	1	1	1	1
Cutting speed [m/s]	0	18	18	22	22	22	22	18
Used wheels		1	1	3	2	2	2	1
Grinding time [s]	20	310	55	95	42	38	20	148
Total cycle time	12min 08s							

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1A1 Ø125 D76
1	11V9 Ø100 D76
1	12V9 Ø125 D64



3. Machine and Software Requirements

Machines: ariesNGP

Coolant: Synthetic Oil, pressure 5 bar

Control: Fanuc 3x

Software: Quinto 5

Accessories:

Responsible engineer: MAM, 19.08.16

www.schneeberger.ch

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

Subsidiaries in: France, Deutschland, Italia, United States, China